

Date: Monday, 7/30/2007 1:54:06 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 205 SKIDTUBE "I" BEAM  
 Job Number : 33796  
 Estimate Number : 10346  
 P.O. Number : *N/A* Part Number : D2596  
 This Issue : 7/30/2007 S.O. No. : *N/A* Drawing Number : D2596 REV D  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *N/A* Type : LANDING GEAR Drawing Revision : D  
 Previous Run : 33451 Material : *N/A*  
 Written By : Due Date : 8/20/2007 Qty: 6 Um: Each  
 Checked & Approved By : *07.07.30*  
 Comment : Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D  
 M  
 Est Rev:E 07-07-09 Incorporated DEO 9183 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D25003100 Ext'n -I' Beam Web 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 Extrusion "I" Beam Web 4"

Pick;

Qty	Part Number	Description	Batch
1	D2500-3-100	Extrusion	<i>B-31223</i>

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr

*-AWN 07/07/02*

3.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



*ANM 07-17/02*



Comment: HAND FINISHING RESOURCE #1  
 Acid Etch and Alodine per QSI 005 4.1

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*EP 07/08/03 (16)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: PA Date: 07/08/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 33796

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 46

DP

7-8-3

6

6.0

QC21

FINAL INSPECTION/W/O RELEASE



6

Comment: FINAL INSPECTION/W/O RELEASE

12/07/08/03

Job Completion



Final 07-08-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

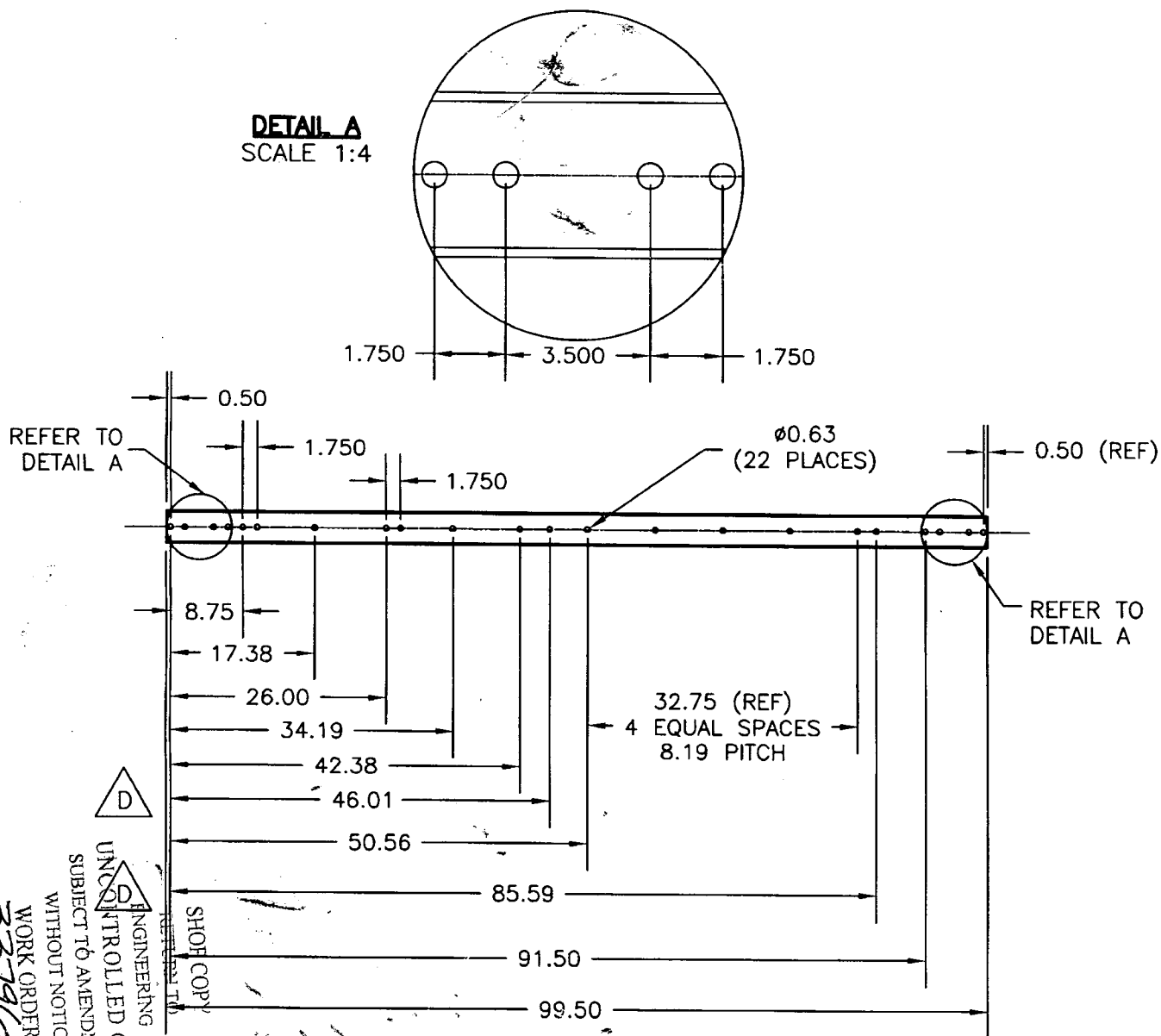
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED  
07 Dec 68

DESIGN	PA	DRAWN BY	PA	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	PA	APPROVED	PA	DRAWING NO.	REV. D
				D2596	SHEET 1 OF 1
DATE				TITLE	SCALE
07.04.17				205 WEB	1:20
A		96.09.16	NEW ISSUE		
B		97.07.23	Ø0.63 HOLE WAS Ø0.56		
C		98.09.14	INCORPORATED DEO 9097		
D		07.04.17	INCORPORATED DEO 9183		



**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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